

LORD® 201 Acrylic Adhesive with LORD Accelerator 17 or 19

Description

LORD® 201 acrylic adhesive when mixed with LORD Accelerator 17 or 19 creates an adhesive system that will bond a wide variety of prepared or unprepared metals and plastics. LORD 201 acrylic adhesive in combination with LORD Accelerator 17 or 19 replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 201 acrylic adhesive can be mixed with either LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 19 is available in off-white or black. For further detailed information on LORD Accelerator 17 and LORD Accelerator 19, refer to the applicable data sheet.

Features and Benefits

Versatile – bonds a wide variety of substrates such as metals, ceramics and plastics; insensitive to minor deviations from correct mix ratio.

Bonds Unprepared Metals – requires little or no substrate preparation.

Self-Leveling – flows into hard-to-reach places and is excellent for bonding irregular shapes.

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to UV exposure, salt spray and weathering.

Temperature Resistant – performs at temperatures from -40 to +300°F (-40 to +149°C).

Application

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Mixing – Mix LORD 201 acrylic adhesive with the proper amount of LORD Accelerator 17 or 19. Hand-held cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

Typical Properties*

Appearance	Off-white Liquid
Viscosity, cP @ 77°F (25°C) Brookfield HBT Spindle 5, 20 rpm	15,000-55,000
Density	
lb/gal	8.5-8.7
(kg/m³)	(1019-1042)
Flash Point (Closed Cup), °F (°C)	66 (19)

*Data is typical and not to be used for specification purposes.

LORD TECHNICAL DATA

Applying – Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

- **Handheld Cartridges**
 1. Load the cartridge into the applicator gun and remove the end caps.
 2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
 3. Attach mixing tip and expel a mixer's length of adhesive.
 4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.
- **Meter/Mix/Dispense Equipment**

Contact your LORD representative if assistance is needed using this equipment. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be steel braided Teflon®.

Curing – Cure begins immediately once adhesive and accelerator are mixed. Handling strength is achieved within 12-16 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (in less than five minutes) after adhesive application.

Teflon is a registered trademark of E.I. duPont de Nemours and Company.

Shelf Life/Storage

Shelf life is six months when stored at temperatures under 80°F (27°C) in original, unopened container. For maximum shelf life, storage temperatures of 40-50°F (4-10°C) are recommended. If stored at these cooler temperatures, allow product to return to room temperature before using.

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

LORD TECHNICAL DATA

Typical Properties* of Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator

A17 10:1

A19 or A19 Black 10:5

Solids Content, % —

Working Time, min @ 75°F (24°C) 5-8

Time to Handling Strength, min @ 75°F.(24°C) 12-16

Mixed Appearance

A17 Tan Paste

A19 Tan Paste

A19 Black Gray Paste

Cured Appearance

A17 Tan to Green

A19 Tan to Green

A19 Black Black

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LORD TECHNICAL DATA

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LORD® 202 Acrylic Adhesive with LORD Accelerator 4, 17, 18 or 19

Description

LORD® 202 acrylic adhesive when mixed with LORD Accelerator 4, 17, 18 or 19 creates a fast curing adhesive system that will quickly bond a wide variety of prepared or unprepared metals and plastics. LORD 202 acrylic adhesive in combination with the recommended accelerator replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 202 acrylic adhesive can be mixed with either LORD Accelerator 4, LORD Accelerator 17, LORD Accelerator 18 or LORD Accelerator 19. LORD Accelerator 4 is a no-mix accelerator applied to the substrate before the acrylic adhesive. LORD Accelerators 17, 18 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator 19 is available in off-white or black. For further detailed information on LORD Accelerator 4, LORD Accelerator 17, LORD Accelerator 18 and LORD Accelerator 19, refer to the applicable data sheet.

Features and Benefits

Convenient – cures very quickly at room temperature.

Versatile – bonds a wide variety of substrates such as metals, ceramics and plastics; can be used with both Mix-In and No-Mix accelerators; insensitive to minor deviations from correct mix ratio.

Self-Leveling – flows into hard-to-reach places and is excellent for bonding irregular shapes.

Bonds Unprepared Metals – requires little or no substrate preparation.

Temperature Resistant – performs at temperatures from -40 to +300°F (-40 to +149°C).

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to UV exposure, salt spray and weathering.

Application

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Typical Properties*

Appearance	Off-white Liquid
Viscosity, cP @ 77°F (25°C) Brookfield HBF Spindle 3, 10 rpm	8,000-32,000
Density	
lb/gal	9.6-10.35
(kg/m ³)	(1150-1240)
Flash Point (Closed Cup), °F (°C)	56 (13)

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LORD TECHNICAL DATA

Mixing

- No-Mix Accelerator

LORD 202 acrylic adhesive and LORD Accelerator 4 are not mixed prior to application.

- Mix-In Accelerator

Mix LORD 202 acrylic adhesive with the proper amount of LORD Accelerator 17, 18 or 19. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

Applying

- No-Mix Accelerator

Allow applied accelerator to thoroughly dry before applying LORD 202 acrylic adhesive. Apply adhesive using a handheld cartridge or automatic dispense equipment.

- Mix-In Accelerator

Apply mixed adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

Handheld Cartridges

1. Load the cartridge into the applicator gun and remove the end caps.
2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
3. Attach mixing tip and expel a mixer's length of adhesive.
4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.

Meter/Mix/Dispense Equipment

Contact your LORD representative if assistance is needed using this equipment. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be steel braided Teflon®.

Curing – Cure begins immediately once adhesive and accelerator come in contact. Handling strength is achieved within 2-4 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (in less than one minute) after adhesive application.

Shelf Life/Storage

Shelf life is six months when stored at temperatures under 80°F (27°C) in original, unopened container. For maximum shelf life, storage temperatures of 40-50°F (4-10°C) are recommended. If stored at these cooler temperatures, allow product to return to room temperature before using.

Cautionary Information

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LORD TECHNICAL DATA

Typical Properties* of Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator

A4	No-Mix
A17	10:1
A18	—
A19 or A19 Black	10:5

Solids Content, %

—

Working Time, min @ 75°F (24°C)

1-2

Time to Handling Strength, min @ 75°F (24°C)

2-4

Mixed Appearance

A4	—
A17	Tan Paste
A18	—
A19	Tan Paste
A19 Black	Gray Paste

Cured Appearance

A4	—
A17	Tan to Green
A18	—
A19	Tan to Green
A19 Black	Black

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LORD® 204 Acrylic Adhesive

with LORD Accelerator 17 or 19

Description

LORD® 204 acrylic adhesive when mixed with LORD Accelerator 17 or 19 creates an adhesive system that will bond a wide variety of prepared or unprepared metals and plastics. LORD 204 acrylic adhesive in combination with LORD Accelerator 17 or 19 replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 204 acrylic adhesive can be mixed with either LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 19 is available in off-white or black. For further detailed information on LORD Accelerator 17 and LORD Accelerator 19, refer to the applicable data sheet.

Features and Benefits

Versatile – bonds a wide variety of substrates such as metals, ceramics and plastics; insensitive to minor deviations from correct mix ratio.

Bonds Unprepared Metals – requires little or no substrate preparation.

Temperature Resistant – performs at temperatures from -40 to +300°F (-40 to +149°C).

Non-Sag – remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to UV exposure, salt spray and weathering.

Application

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Mixing – Mix LORD 204 acrylic adhesive with the proper amount of LORD Accelerator 17 or 19. Hand-held cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the acrylic adhesive cures rapidly.

Typical Properties*

Appearance	Off-white Paste
Viscosity, cP @ 77°F (25°C) Brookfield HAT Spindle 7, 20 rpm	100,000-300,000
Density	
lb/gal	8.7-9.3
(kg/m³)	(1042-1114)
Flash Point (Closed Cup), °F (°C)	66 (19)

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LORD TECHNICAL DATA

Applying – Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

- **Handheld Cartridges**
 1. Load the cartridge into the applicator gun and remove the end caps.
 2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
 3. Attach mixing tip and expel a mixer's length of adhesive.
 4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.
- **Meter/Mix/Dispense Equipment**

Contact your LORD representative if assistance is needed using this equipment. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be steel braided Teflon®.

Curing – Cure begins immediately once adhesive and accelerator are mixed. Handling strength is achieved within 12-16 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible after adhesive application.

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Shelf Life/Storage

Shelf life is six months when stored at temperatures under 80°F (27°C) in original, unopened container. For maximum shelf life, storage temperatures of 40-50°F (4-10°C) are recommended. If stored at these cooler temperatures, allow product to return to room temperature before using.

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

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Typical Properties* of Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator

A17	10:1
A19 or A19 Black	10:5
Solids Content, %	100
Working Time, min @ 75°F (24°C)	6-8
Time to Handling Strength, min @ 75°F (24°C)	12-16

Mixed Appearance

A17	Tan Paste
A19	Tan Paste
A19 Black	Gray Paste

Cured Appearance

A17	Tan to Green
A19	Tan to Green
A19 Black	Black

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LORD TECHNICAL DATA

Typical Cured Properties

Tensile Strength at Break, psi (MPa)	—
ASTM D638, modified	
Elongation, %	4.9
ASTM D638, modified	
Young's Modulus, psi (MPa)	140,826 (971.0)
ASTM D638, modified	
Glass Transition Temperature, °F (°C)	—
ASTM E1640-99, by DMA	

Bond Performance

Substrates	Aluminum to Aluminum	Galvanized Steel to Galvanized Steel	Powder Coated Steel to Powder Coated Steel	ABS to ABS
Lap Shear @ Room Temperature, psi (MPa)	2990 (20.6)	2730 (18.8)	2640 (18.2)	570 (3.9)
Failure Mode	C/A	C/A	A	SB
Lap Shear @ Hot Strength [180°F (82°C)], psi (MPa)	1920 (13.2)	1750 (12.1)	930 (6.4)	50 (0.3)
Failure Mode	C/TLC	C	A	SB
Lap Shear after 500 hours Salt Spray Exposure, psi (MPa)	2840 (19.6)	2310 (15.9)	3010 (20.8)	—
Test after 24 hours				
Failure Mode	TLC	C	CF/A	—
Lap Shear after 14 days @ 100°F (38°C), 100% RH, psi (MPa)	3000 (20.7)	2670 (18.4)	2290 (15.8)	—
Failure Mode	TLC	CF/A	A	—
Lap Shear @ -30°F (-34°C), psi (MPa)	1570 (10.8)	2420 (16.7)	1880 (13.0)	680 (4.7)
Failure Mode	A	A	CF/A	SB
T-Peel, pli (N/mm)	29 (5.1)	47 (8.2)	37 (6.5)	—
Failure Mode	C	C	C/TLC	—

Substrate

Aluminum, 0.032" thick 6061T6
 Galvanized Steel, 0.030" thick electrogalvanized
 Powder Coated Steel, 0.035" thick, polyester on cold rolled steel
 Acrylonitrile Butadiene Styrene (ABS), 0.125" thick hair cell ABS

Surface Treatment

Dry Rag Wipe
 Dry Rag Wipe
 Dry Rag Wipe
 Dry Rag Wipe

Bonded Parameters

Metal Lap Shears (ASTM D1002)
 ABS Lap Shears (ASTM D3163)
 T-Peel (ASTM D1876 modified)

Bond Area

1.0"x0.5"
 1.0"x1.0"
 1.0"x3.0"

Film Thickness

0.010"
 0.010"
 0.010"

Cure

24 hr @ RT
 24 hr @ RT
 72 hr @ RT

Mix Ratio

4:1 by Volume
 4:1 by Volume
 4:1 by Volume

Failure Mode Definition

Adhesive Failure
 Cohesive Failure
 Coating Failure
 Stock Break
 Thin Layer Cohesive Failure

Abbreviation

A
 C
 CF
 SB
 TLC

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LORD® 206 Acrylic Adhesive with LORD Accelerator 4, 17 or 19

Description

LORD® 206 acrylic adhesive when mixed with LORD Accelerator 4, 17 or 19 creates a long working time adhesive system that bonds a wide variety of prepared or unprepared metals and plastics. LORD 206 acrylic adhesive in combination with the recommended accelerator replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 206 acrylic adhesive can be mixed with either LORD Accelerator 4, LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 4 is a no-mix accelerator applied to the substrate before the acrylic adhesive. LORD Accelerators 17 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator 19 is available in off-white or black. For further detailed information on LORD Accelerator 4, LORD Accelerator 17 and LORD Accelerator 19, refer to the applicable data sheet.

Features and Benefits

Convenient – provides long working time, reducing adhesive waste.

Bonds Unprepared Metals – requires little or no substrate preparation.

Versatile – bonds a wide variety of substrates such as metals, ceramics and plastics; can be used with both Mix-In and No-Mix accelerators; insensitive to minor deviations from correct mix ratio.

Temperature Resistant – performs at temperatures from -40 to +300°F (-40 to +149°C).

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to UV exposure, salt spray and weathering.

Application

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Typical Properties*

Appearance	Off-white Liquid
Viscosity, cP @ 77°F (25°C) Brookfield HAT Spindle 7, 20 rpm	20,000-80,000
Density	
lb/gal	8.5-8.7
(kg/m³)	(1019-1042)
Flash Point (Closed Cup), °F (°C)	66 (19)

*Data is typical and not to be used for specification purposes.

LORD TECHNICAL DATA

Mixing

- **No-Mix Accelerator**
LORD 206 acrylic adhesive and LORD Accelerator 4 are not mixed prior to application.
- **Mix-In Accelerator**
Mix LORD 206 acrylic adhesive with the proper amount of LORD Accelerator 17 or 19. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the acrylic adhesive cures rapidly.

Applying

- **No-Mix Accelerator**
Allow applied accelerator to thoroughly dry before applying LORD 206 acrylic adhesive. Apply adhesive using a handheld cartridge or automatic dispense equipment.
- **Mix-In Accelerator**
Apply mixed adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

Handheld Cartridges

1. Load the cartridge into the applicator gun and remove the end caps.
2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
3. Attach mixing tip and expel a mixer's length of adhesive.
4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.

Meter/Mix/Dispense Equipment

Contact your LORD representative if assistance is needed using this equipment. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be steel braided Teflon®.

Curing – Cure begins immediately once adhesive and accelerator come in contact. Handling strength is achieved within 45 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (in less than ten minutes) after adhesive application.

Shelf Life/Storage

Shelf life is six months when stored at temperatures under 80°F (27°C) in original, unopened container. For maximum shelf life, storage temperatures of 40-50°F (4-10°C) are recommended. If stored at these cooler temperatures, allow product to return to room temperature before using.

Cautionary Information

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Typical Properties* of Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator

A4	No-Mix
A17	10:1
A19 or A19 Black	10:5

Solids Content, %

—

Working Time, min @ 75°F (24°C)

12-14

Time to Handling Strength, min @ 75°F (24°C)

45-60

Mixed Appearance

A4	—
A17	Tan Paste
A19	Tan Paste
A19 Black	Gray Paste

Cured Appearance

A4	—
A17	Tan to Green
A19	Tan to Green
A19 Black	Black

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